

10-03-00

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**PATENT APPLICATION TRANSMITTAL LETTER**  
(Large Entity)

Docket No.  
0230CG-101

TO THE ASSISTANT COMMISSIONER FOR PATENTS

Transmitted herewith for filing under 35 U.S.C. 111 and 37 C.F.R. 1.53 is the patent application of:

**Bradford G. Corbett, Jr.**

For: **PIPE BELLING APPARATUS AND METHOD**

Enclosed are:

- ☒ Certificate of Mailing with Express Mail Mailing Label No. **EL1391644405US**
- ☒ Four (4) sheets of drawings.
- ☐ A certified copy of a application.
- ☒ Declaration ☒ Signed. ☐ Unsigned.
- ☒ Power of Attorney
- ☐ Information Disclosure Statement
- ☐ Preliminary Amendment
- ☒ Other: **Postcard**

**CLAIMS AS FILED**

For	#Filed	#Allowed	#Extra	Rate	Fee
<b>Total Claims</b>	11	- 20 =	0	x \$18.00	\$0.00
<b>Indep. Claims</b>	3	- 3 =	0	x \$78.00	\$0.00
<b>Multiple Dependent Claims (check if applicable)</b> <input type="checkbox"/>					\$0.00
<b>BASIC FEE</b>					\$710.00
<b>TOTAL FILING FEE</b>					\$710.00

- ☒ A check in the amount of **\$710.00** to cover the filing fee is enclosed.
- ☒ The Commissioner is hereby authorized to charge and credit Deposit Account No. **06-0580** as described below. A duplicate copy of this sheet is enclosed.
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- ☐ Charge the issue fee set in 37 C.F.R. 1.18 at the mailing of the Notice of Allowance, pursuant to 37 C.F.R. 1.311(b).

Dated: **10-2-2000**

*Charles D. Gunter, Jr.*  
Signature

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CC:

S P E C I F I C A T I O N

Docket No. 0230G-101

TO ALL WHOM IT MAY CONCERN:

BE IT KNOWN that I, Bradford G. Corbett, Jr., a citizen of the United States, residing in Ft. Worth, Texas, have invented new and useful improvements in a

PIPE BELLING APPARATUS AND METHOD

of which the following is a specification:

"EXPRESS MAIL" NO. <i>ELI 39 164405 US</i>	
I hereby certify that this paper or fee is being deposited with the United States Postal Service as "Express Mail Post Office to Addressee" service under 37 C.F.R. § 1.10 on the date indicated below and is addressed to the Assistant Commissioner for Patents, Washington, D.C. 20231.	
Date of Deposit: <i>10-2-00</i>	By: <i>Barak Horner</i>

## BACKGROUND OF THE INVENTION

### 1. Field of the Invention:

The present invention relates generally to sealing systems for thermoplastic pipes and, specifically, to an improved bellng apparatus and process for installing a gasket in a socket end of a thermoplastic pipe.

### 2. Description of the Prior Art:

Pipes formed from thermoplastic materials including polyethylene and PVC are used in a variety of industries. In forming a joint between sections of pipe, the spigot or male pipe end is inserted within the female or socket pipe end. An annular, elastomeric ring or gasket is typically seated within a groove formed in the socket end of the thermoplastic pipe. As the spigot is inserted within the socket, the gasket provides the major seal capacity for the joint. It is critical, during the installation process, that the gasket not be able to twist or flip since a displaced or dislocated gasket will adversely affect the ultimate sealing capacity of the joint.

A variety of other shortcomings have existed in such pipe joints of the prior art. For example, unintentional earth loading, such as traffic load, can be transferred to the socket end of the pipe sections, leading to deformations and associated leakage in the joints. Certain heat strains in the pipes, such as can occur on storage in hot weather or by close proximity to heat

1 sources can result in deformations, shrinkage of the pipe  
2 material and resulting leakage.

3  
4 One early attempt to ensure the integrity of such  
5 pipe joints was to provide local reinforcement of the  
6 groove portion of the socket end by means of a heavier  
7 wall thickness in this region of the pipe. In some  
8 cases, reinforcing sleeves or external connecting  
9 mechanisms were also utilized. Each of these solutions  
10 was less than ideal, in some cases failing to provide the  
11 needed joint integrity and often contributing to the  
12 complexity and expense of the manufacturing or field  
13 assembly operations.

14  
15 In the early 1970's, a new technology was developed  
16 by Rieber & Son of Bergen, Norway, referred to in the  
17 industry as the "Rieber Joint." The Rieber system  
18 employed a combined mould element and sealing ring for  
19 sealing a joint between the socket end and spigot end of  
20 two cooperating pipes formed from thermoplastic  
21 materials. In the Rieber process, the elastomeric gasket  
22 was inserted within an internal groove in the socket end  
23 of the female pipe as the female or belling end was  
24 simultaneously being formed. The provision of a  
25 prestressed and anchored elastomeric gasket during the  
26 belling process at the pipe factory provided an improved  
27 socket end for a pipe joint with a sealing gasket which  
28 would not twist or flip or otherwise allow impurities to  
29 enter the sealing zones of the joint. These features  
30 increased the reliability of the joint and decreased the  
31 risk of leaks or possible failure due to abrasion or  
32 other factors. The Rieber process is described in the

1 following issued United States patents: 4,120,521;  
2 4,061,459; 4,030,872; 3,965,715; 3,929,958; 3,887,992;  
3 3,884,612; and 3,776,682.

4  
5 Certain of the polyolefin materials were not well  
6 adapted for use in the Rieber-type process. Polyethylene,  
7 for example, after being heated has a tendency to return  
8 to its original shape. Thus, after a bell connection is  
9 formed using the traditional Rieber techniques of  
10 heating, forming and cooling, the end result is a shape  
11 that is not stable.

12  
13 Accordingly, an object of the present invention is  
14 to provide a method of installing a gasket in a socket  
15 end of a thermoplastic pipe, including a polyethylene  
16 pipe, in a Rieber-type process which provides a stable  
17 shape upon cooling.

18  
19 Another object is to provide such a manufacturing  
20 technique which is simple to implement and which provides  
21 reliable results.

22  
23 Another object of the invention is to provide an  
24 integral gasket within the socket end of a polyethylene  
25 pipe which is securely retained within a receiving groove  
26 which is integrally formed about the gasket during the  
27 manufacturing step.

28  
29 Another object of the invention is to allow the  
30 manufacturing of very large diameter gasketed pipe at a  
31 lower cost than traditional methods.

**SUMMARY OF THE INVENTION**

A method is shown for installing a gasket in a socket end of a thermoplastic pipe which is used to form a pipe coupling. A mandrel is provided with an inner extent and an outer extent and having a generally cylindrical outer working surface. A gasket is installed at a first circumferential position on the outer working surface. An extruded strip of thermoplastic material is spirally wrapped about the working surface of the mandrel and over the gasket, whereby the thermoplastic material is conformed to the shape of the gasket. A leading portion of the gasket again contacts the working surface of the mandrel to form a bell connection. The bell connection with the integrally contained gasket can then be retracted from the working surface of the mandrel. The thus formed bell connection can be electrowelded onto a generally cylindrical length of thermoplastic pipe to form a pipe joint.

In a preferred embodiment of the invention, a rotatably driven mandrel is provided having a substantially cylindrical end section corresponding to the internal diameter of a bell connection to be formed. The mandrel has an outer extent and an inner extent and also has a locating area for an elastomeric gasket on an external working surface thereof. The elastomeric gasket is positioned on the external surface of the mandrel at the locating area thereof, the locating area being between the inner and outer extents of the mandrel. A bell connection is then formed about the mandrel and suitably located gasket by extruding a melt profile made

1 of thermoplastic material onto the mandrel beginning  
2 adjacent the inner extent of the mandrel and spirally  
3 winding the melt profile around the cylindrical end  
4 section of the mandrel and around the gasket such that  
5 adjacent windings of the melt profile make contact and  
6 are fused. The bell connection thus formed is then cooled  
7 and the bell connection and gasket are stripped from the  
8 mandrel.

9  
10 Additional objects, features and advantages will be  
11 apparent in the written description which follows.

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## BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a simplified, partially schematic view of the apparatus and method of the invention showing the mandrel upon which the thermoplastic material is being extruded and wrapped;

Figure 2 is a side, partial cross-sectional view of the mandrel used in the method of the invention showing the elastomeric gasket located on the external working surface thereof;

Figure 3 is a view similar to Figure 2, showing the beginning of the extrusion step of the method of the invention;

Figures 4 and 5 are a continuation of Figure 3 showing the further extrusion steps of the method of the invention;

Figure 6 is a side, partial cross sectional view showing the bell connection and integral gasket having been stripped from the forming mandrel;

Figures 10-13 are simplified, schematic views of the prior art Rieber process for installing a gasket in a socket end of a thermoplastic pipe.



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## DETAILED DESCRIPTION OF THE INVENTION

The advantages of the method of the invention can best be understood with reference to a simplified discussion of the prior art Rieber process. Turning first to Figures 7-10, the prior art process is illustrated. Figure 7 shows a section of a conventional elastomeric sealing gasket 11 having a steel reinforcing ring 13 in place on the generally cylindrical outer working surface 15 of the mandrel 17 used in the belling process. The elastomeric gasket 11 can be formed of, for example, rubber and is a ring shaped, circumferential member having an inner compression surface 19 and an exposed nose portion 21 which, as shown in Figure 1, abuts a forming collar 23. The forming collar 23 has a first generally cylindrical extent 25 which is joined to a second cylindrical extent 27 by a step region 29, whereby the second extent 27 is of greater external diameter than the first cylindrical extent 25, shown in Figure 7.

In the first step of the prior art process, the steel reinforced elastomeric ring 11 is thus placed onto the working surface of the mandrel 17 and pushed to a position against the back-up or forming collar 23. In this position, the gasket is firmly anchored to the mandrel surface with the rubber between the mandrel and the steel-ring of the gasket being compressed by approximately 20%.

In the second step of the prior art process, the socket end 33 of the thermoplastic pipe 31 is heated and

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1 pushed over the steel mandrel 17, gasket 11 and back-up  
2 collar 23. The socket end 33 is expanded due to the  
3 thermoplastic nature of the pipe. A number of  
4 thermoplastic materials, such as polyvinylchloride (PVC)  
5 are known in the prior art having the required expansion  
6 characteristics, depending upon the end application of  
7 the pipe joint.

8

9 The socket end 33 flows over the first cylindrical  
10 extent 25 of the back-up collar 23 and abuts the step  
11 region 29 in the second step of the process (see Figure  
12 8).

13

14 In the next step of the prior art process (Figure 9)  
15 hydraulic cylinders are actuated to move the mandrel and  
16 pipe away from the back-up collar 23 and the pipe socket  
17 end 33 retracts around the mandrel and gasket 11 due to  
18 the elastic forces of the thermoplastic material.  
19 Typically, vacuum was also applied through ports 35, 37  
20 which connected the mandrel working surface with a vacuum  
21 source (not shown).

22

23 In the final step of the prior art process (Figure  
24 10), the pipe socket end 33 is cooled by means of a water  
25 spray bar 39 and spray nozzles 41. As the cooling takes  
26 place, the pipe socket end 33 shrinks around the gasket  
27 11, thus compressing the rubber body of the gasket  
28 between the steel reinforcing ring 13 and the socket-  
29 groove to establish a firm seal.

30

31 The above described Rieber process has been in  
32 commercial use since the early 1970's and is described in



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1 the vertical shoulder region 59 of the mandrel to assist  
2 in retaining the gasket in position on the mandrel during  
3 the subsequent manufacturing steps.

4

5 As shown schematically in Figure 1, the mandrel 43  
6 is connected to a rotary drive 83 which rotates the  
7 mandrel about a longitudinal axis 85 thereof.

8

9 The apparatus of the invention also includes an  
10 extruder head 67 having a nozzle 69 (Figure 1). The  
11 extruder head 67 is movable along the axes indicated as  
12 71, 73 in Figure 1 so that the apparatus can lay down a  
13 strip of thermoplastic material with the strip being  
14 spirally wound about the working surface of the mandrel  
15 and over the gasket 75 as the mandrel turns about the  
16 axis 85 as shown in Figure 1. In other words, the mandrel  
17 43 is rotated about its axis 85 while a strip of  
18 thermoplastic material (87 in Figure 3) is wrapped around  
19 the mandrel 43. The extruder head's axis 89 is  
20 perpendicular to the rotational plane of the mandrel 43.  
21 The extruder head 67 is also displaced in the direction  
22 of the mandrel axis 85 in order to lay down the spiral  
23 strip 87. As shown in Figure 1, the apparatus can also  
24 have other conventional accessory devices such as the  
25 pressure roller 91 and cutting knife 93 to facilitate  
26 placement of the strip 87 and termination of the  
27 extrusion.

28

29 Figures 2-6 illustrate the method steps of the  
30 invention in schematic fashion. In Figure 2, the gasket  
31 75 is first mounted on the forming mandrel 43 in the  
32 stepped region 57 thereof. Figures 3 and 4 shown the

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1 extrusion of the thermoplastic material with the strip  
2 forming around the gasket and mandrel.

3

4 A number of thermoplastic materials may have the  
5 desired expansion characteristics for use in the method  
6 of the invention. The generally preferred materials are  
7 polyolefin type materials, such as polyethylene,  
8 polyvinylchloride, polyvinylchloride acetate,  
9 polystyrene, and the like. The most preferred material is  
10 commercially available polyethylene.

11

12 Preferably, the mandrel 43 is continuously rotated  
13 and heated. The heating can be accomplished in  
14 conventional fashion, as by use of a gas blower from  
15 inside the mandrel or outside, or in an inductive way  
16 from outside the mandrel. When the mandrel has reached  
17 the desired temperature, a melt profile of the  
18 thermoplastic material is extruded onto the working  
19 surface of the mandrel beginning at the inner cylindrical  
20 extent 47 adjacent the end 55. The extrusion is  
21 preferably carried out using an extruder nozzle 69 of  
22 substantially rectangular cross section, the nozzle being  
23 movable in an axial direction along the mandrel, as  
24 previously discussed.

25

26 Preferably, the movement of the extruder head 67 is  
27 synchronized with the movement of the mandrel such that  
28 the extruder nozzle, for each rotation of the mandrel 43,  
29 moves in a direction toward the mandrel end 53 a distance  
30 that is slightly less than the width of the melt profile  
31 being extruded such that a slight overlap is obtained. In  
32 this way, a spiral winding of the melt profile around the

1 mandrel and gasket is obtained with the turns of the  
2 winding being located tightly above one another such that  
3 a welding-together of the melt profiles is obtained. The  
4 heated roll 91 can be used to improve the welding  
5 together of the strips and for obtaining a more uniform  
6 exterior surface of the welded body.

7

8 The extrusion continues until a desired length of  
9 bell connection is obtained, after which the extruder is  
10 stopped. When the extrusion is stopped, the thermoplastic  
11 material is typically cooled down by spraying with  
12 cooling water from the outside of the extruded bell  
13 connection. The wrapping process is now complete and the  
14 gasket 75 is completely encapsulated. The rotating knife  
15 93 with its rotating blade may be pressed in a hydraulic  
16 or mechanical way against the spiral windings to provide  
17 cleanly cut ends on the connection. After the  
18 thermoplastic material has cooled and set, the finished  
19 "bell" can be stripped from the mandrel.

20

21 The stripping step can be accomplished in any  
22 convenient manner, as by blowing pressurized air between  
23 the mandrel and melt profile through port 65 at the same  
24 time that a pushing force is directed against the melt  
25 profile along the axis 85 of the mandrel. As shown in  
26 Figure 6, the formed bell can be electrowelded or  
27 otherwise joined to a straight piece of pipe so that a  
28 final gasketed joint of pipe is obtained.

29

30 An invention has been provided with several  
31 advantages. The improved apparatus and method provide a  
32 bell connection formed from polyethylene which is not

1 subject to many of the deficiencies of the prior art due  
2 to the physical properties of polyethylene and its  
3 tendency to revert to its original shape after being  
4 heated, formed and cooled. The bell pipe connection of  
5 the invention is stable and maintains its desired shape  
6 characteristics. The mechanism for forming the bell  
7 connection is relatively simple in design and operation,  
8 thereby providing a cost effective manufacturing process.  
9 The integral gasket design of the connection provides  
10 improved reliability over designs which require insertion  
11 of a gasket after manufacture of the pipe joint or in the  
12 field.

13  
14 While the invention has been shown in only one of  
15 its forms, it is not thus limited but is susceptible to  
16 various changes and modifications without departing from  
17 the spirit thereof.

1 What is claimed is:

2

3 1. A method of installing a gasket in a socket end of a  
4 thermoplastic pipe which is used to form a pipe coupling,  
5 the method comprising the steps of:

6

7 providing a mandrel with an inner extent and an outer  
8 extent and having a generally cylindrical outer working  
9 surface;

10

11 installing a gasket at a first circumferential position  
12 on the outer working surface;

13

14 extruding a strip of thermoplastic material and spirally  
15 wrapping the extruded strip about the working surface of  
16 the mandrel and over the gasket, whereby the  
17 thermoplastic material is conformed to the shape of the  
18 gasket to form a retention groove for retaining the  
19 gasket and again contacts the working surface of the  
20 mandrel to form a bell connection;

21

22 retracting the bell connection and the retained gasket  
23 from the working surface of the mandrel.

24

25 2. The method of claim 1, further comprising the steps  
26 of:

27

28 electrowelding the thus formed bell connection onto a  
29 generally cylindrical length of thermoplastic pipe.

30

31 3. The method of claim 1, wherein the thermoplastic  
32 material is polyethylene.



1 4. A method of manufacturing an integrated bell  
2 connection for a joint of thermoplastic pipe, the method  
3 comprising the steps of:  
4  
5 providing a rotatably driven mandrel having a  
6 substantially cylindrical end section corresponding to  
7 the internal diameter of a bell connection to be formed,  
8 the mandrel having an outer extent and an inner extent,  
9 the mandrel having a locating area for an elastomeric  
10 gasket on an external surface thereof;  
11  
12 positioning an elastomeric gasket on the external surface  
13 of the mandrel at the locating area thereof, the locating  
14 area being between the inner and outer extents of the  
15 mandrel;  
16  
17 forming a bell connection about the mandrel and suitably  
18 located gasket by extruding a melt profile made of  
19 thermoplastic material onto the mandrel beginning  
20 adjacent the inner extent of the mandrel and spirally  
21 winding the melt profile around the cylindrical end  
22 section of the mandrel and around the gasket such that  
23 adjacent windings of the melt profile make contact;  
24  
25 cooling the bell connection thus formed;  
26  
27 removing the bell connection and gasket from the mandrel.  
28  
29 5. A method of manufacturing an integral gasket and bell  
30 connection for a joint of thermoplastic pipe, the method  
31 comprising the steps of:  
32

1 providing a rotatably driven mandrel having a  
2 substantially cylindrical end section corresponding to  
3 the internal diameter of a bell connection to be formed,  
4 the mandrel having an outer extent and an inner extent,  
5 the mandrel having a locating area for an elastomeric  
6 gasket on an external surface thereof;  
7  
8 positioning an elastomeric gasket on the external surface  
9 of the mandrel at the locating area thereof, the locating  
10 area being between the inner and outer extents of the  
11 mandrel;  
12  
13 forming a bell connection about the mandrel and suitably  
14 located gasket by extruding a melt profile made of  
15 thermoplastic material onto the mandrel beginning  
16 adjacent the inner extent of the mandrel and spirally  
17 winding the melt profile around the cylindrical end  
18 section of the mandrel and around the gasket such that  
19 adjacent windings of the melt profile make contact;  
20  
21 terminating the extruding step while continuing to rotate  
22 the mandrel;  
23  
24 spraying cooling water over the bell end connection thus  
25 formed;  
26  
27 cutting a free end of the connection with a rotating  
28 knife;and  
29  
30 removing the bell end connection and integral gasket from  
31 the mandrel.  
32

1 6. The method of claim 5, wherein the thermoplastic  
2 material being extruded is polyethylene.

3

4 7. The method of claim 5, wherein the mandrel is heated  
5 to at least about 100 degrees C. before the melt profile  
6 is extruded.

7

8 8. The method of claim 5, further comprising the step of  
9 subjecting the extruded melt profile to a weak mechanical  
10 loading by means of a rotating roll for intensifying a  
11 welding-together of the contacting melt profile windings.

12

13 9. The method of claim 5, wherein the rotating knife  
14 comprises a freely rotating circular blade which is  
15 pressed against the thermoplastic material of the bell  
16 end connection for cutting the free end of the  
17 connection.

18

19 10. The method of claim 5, further comprising the steps  
20 of:

21

22 removing the bell connection from the mandrel by blowing  
23 pressurized air between the mandrel and the connection  
24 while directly pushing the connection in a direction  
25 opposite the mandrel.

26

27 11. The method of claim 10, further comprising the step  
28 of:

29

electrowelding the thus formed bell connection onto a  
generally cylindrical length of thermoplastic pipe.

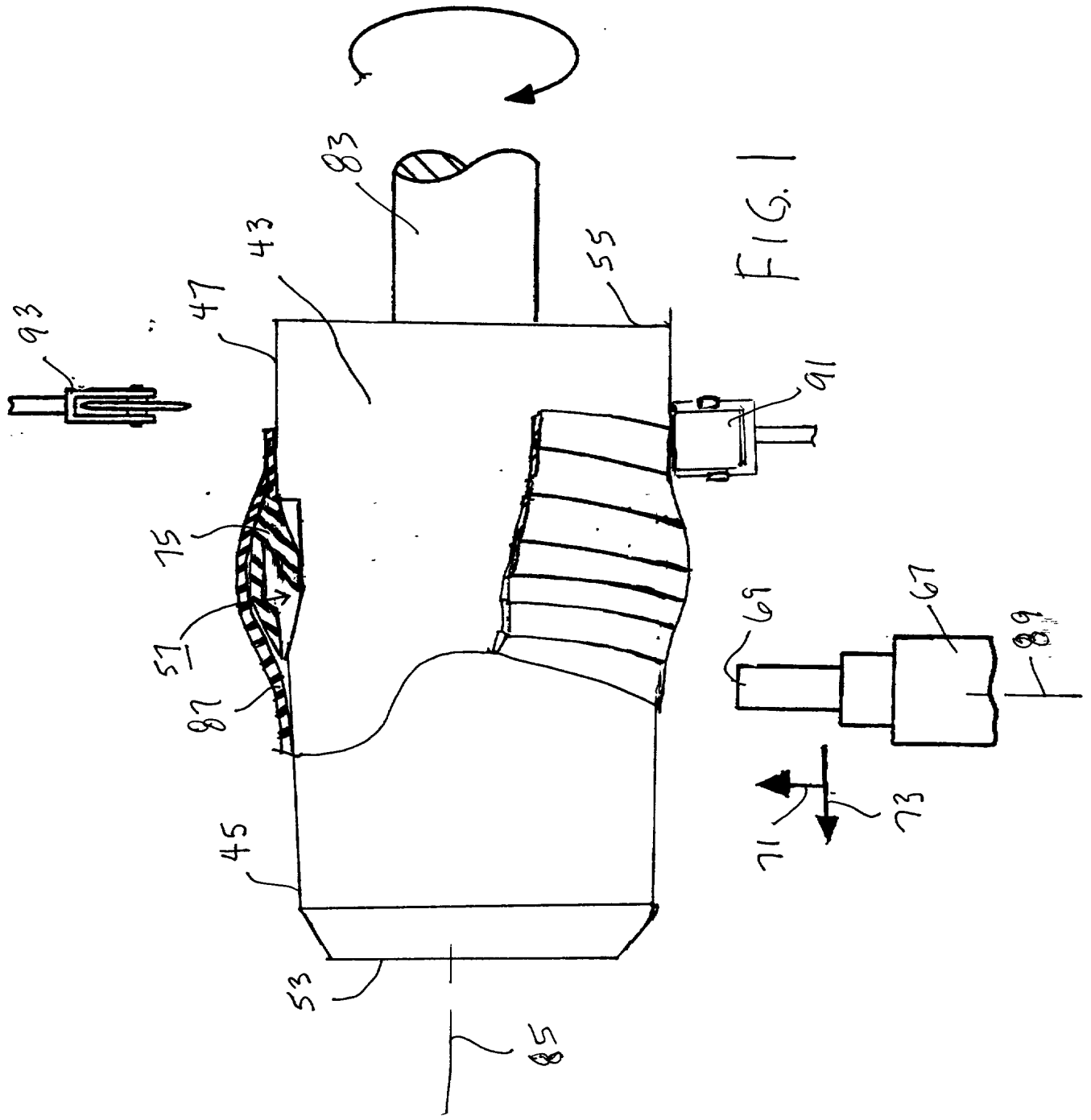
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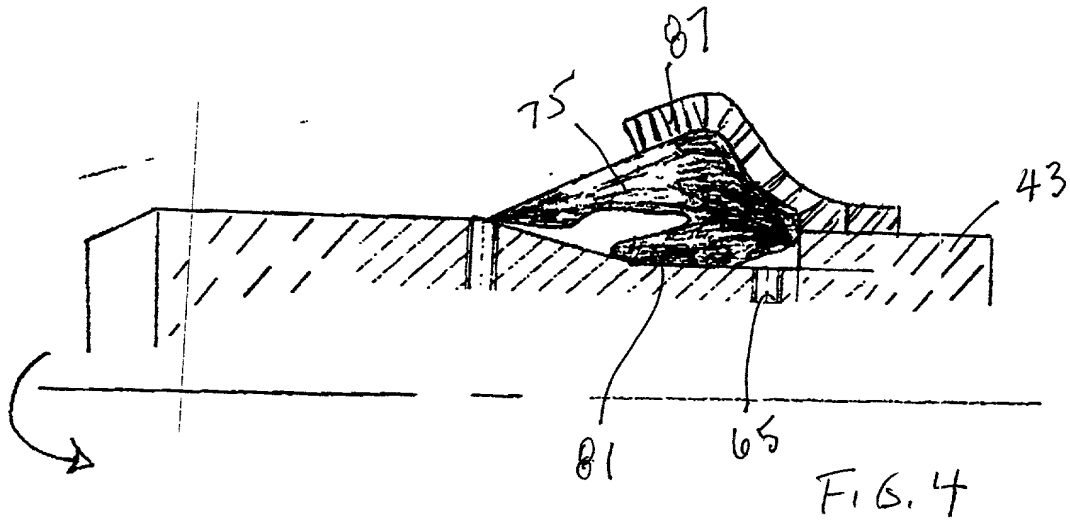
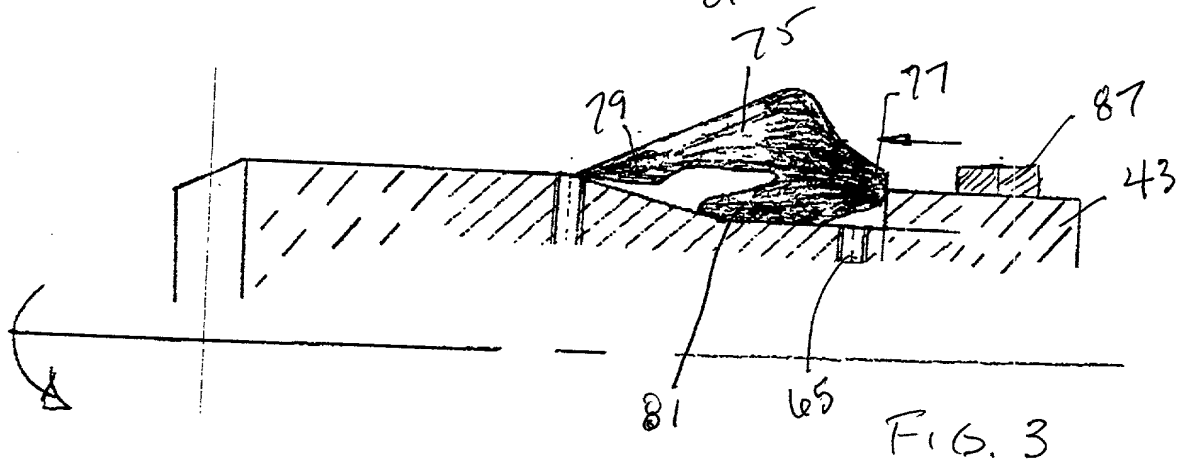
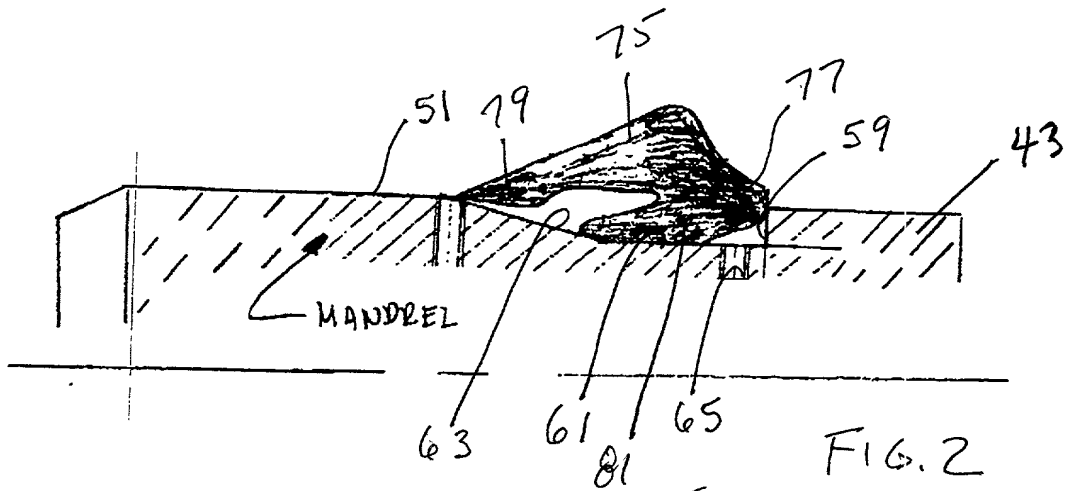
1                   **ABSTRACT OF THE DISCLOSURE**

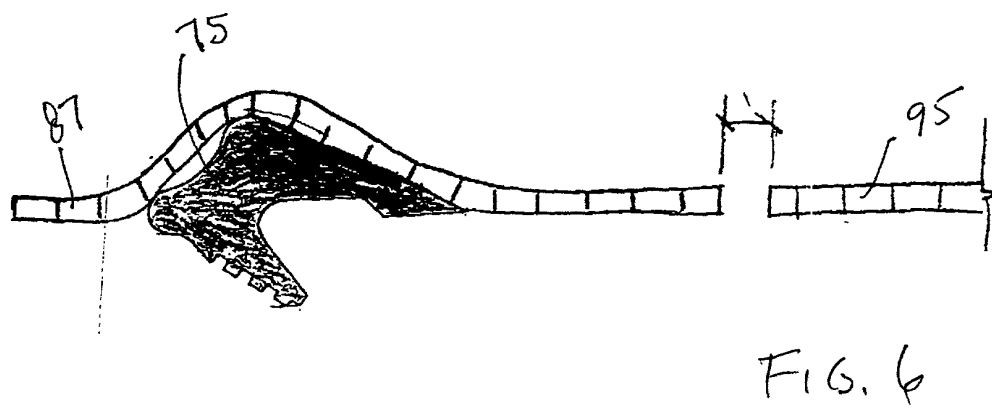
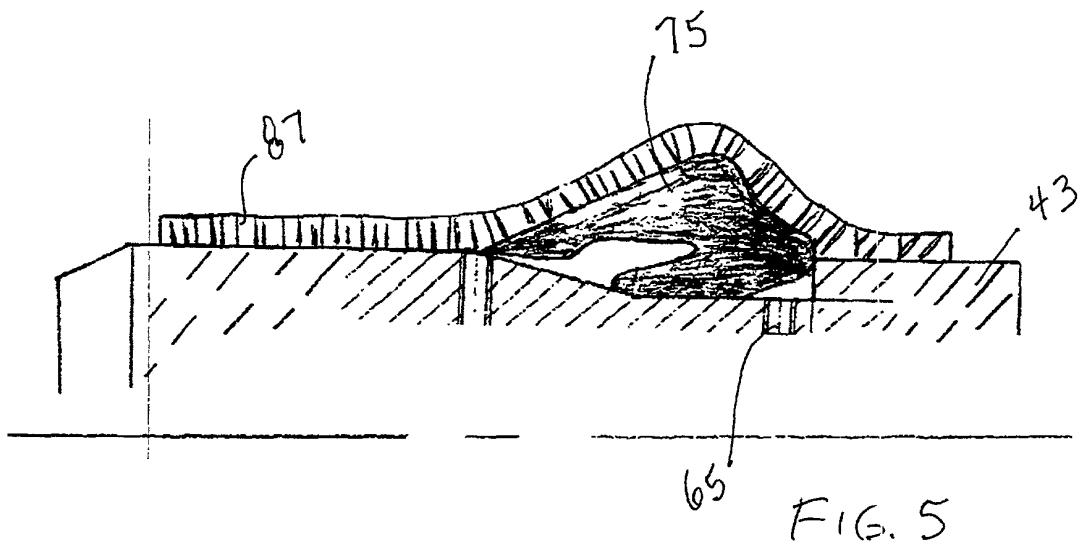
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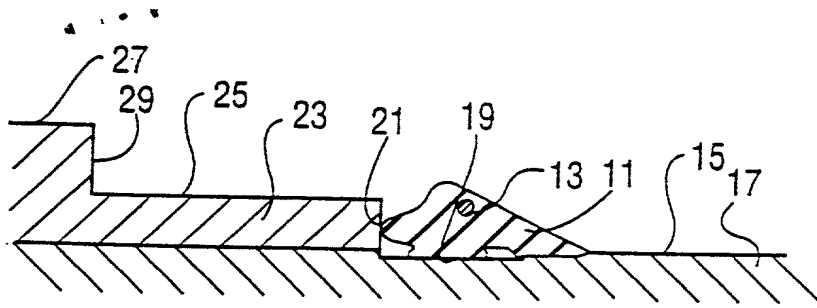
3           An improved pipe bellling apparatus and method are  
4 shown in which a spiral strip of thermoplastic material  
5 is extruded and wrapped spirally about a mandrel and  
6 integral gasket. The heated material is allowed to cool  
7 and the connection thus formed is stripped from the  
8 mandrel. The gasket is retained within a groove which is  
9 simultaneously formed of the thermoplastic extrusion.

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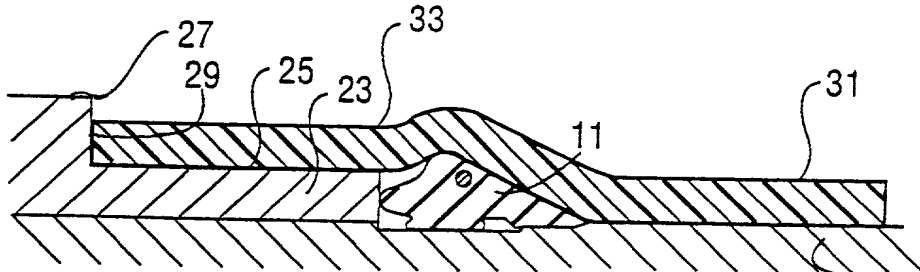






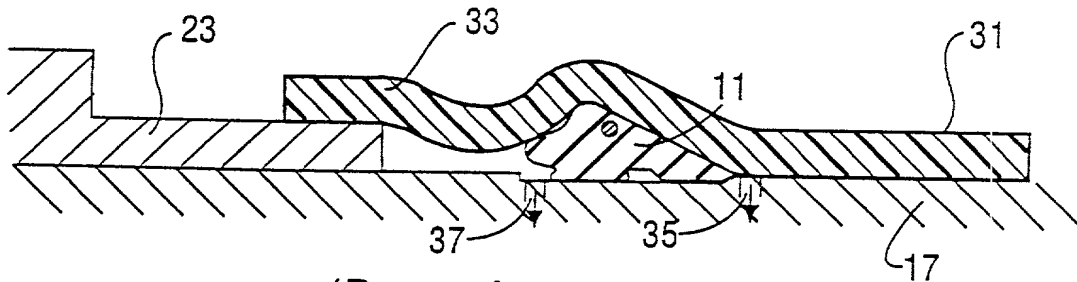
(PRIOR ART)

FIG. 7



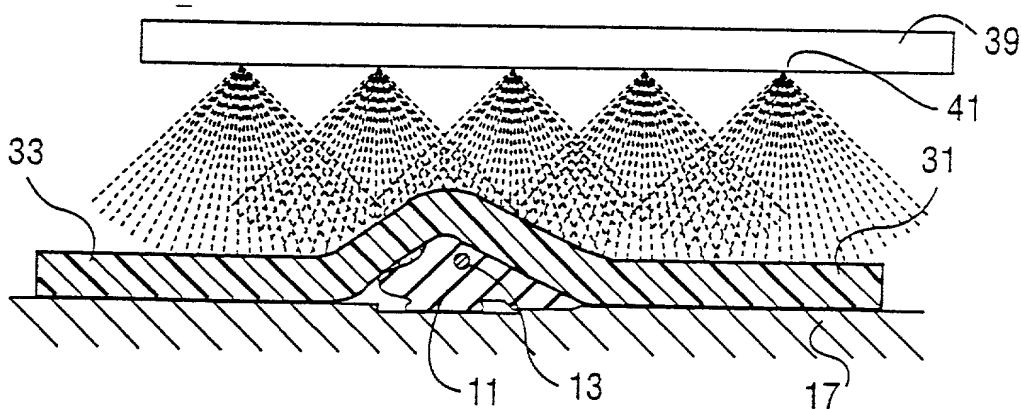
(PRIOR ART)

FIG. 8



(PRIOR ART)

FIG. 9



(PRIOR ART)

FIG. 10



## DECLARATION FOR PATENT APPLICATION

As a below named inventor, I hereby declare that:

My residence, post office address, and citizenship are as stated below next to my name,

I believe I am the original, first, and sole inventor (if only one name is listed below) or an original, first, and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

### PIPE BELLING APPARATUS AND METHOD

the specification of which is attached hereto; or which was filed on \_\_\_\_\_,  
Serial No. \_\_\_\_\_.

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the patentability of this application in accordance with Title 37, Code of Federal Regulations, Section 1.56.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

I hereby appoint **Robert A. Felsman**, Reg. No. **22,107**; **James E. Bradley**, Reg. No. **27,536**; **Charles D. Gunter, Jr.**, Reg. No. **29,386**; **Andrew J. Dillon**, Reg. No. **29,634**; **Melvin A. Hunn**, Reg. No. **32,574**; **Kenneth C. Hill**, Reg. No. **29,650**; **Duke W. Yee**, Reg. No. **34,285**; and **Grady K. Bergen**, Reg. No. **37,587**, to prosecute this application and to transact all business in the U.S. Patent and Trademark Office in connection therewith.

Please send all correspondence to:

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Inventor's Signature: \_\_\_\_\_

*Bradford G. Corbett*

Full Name of Sole or First Inventor: Bradford G. Corbett, Jr.

Date of Signature: \_\_\_\_\_

*11-15-99*

Residence Address: \_\_\_\_\_

*64 WESTOVER TERRACE FW TX*

Citizenship: \_\_\_\_\_

*USA*

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